

# Work Order ID 93030

Tuesday, November 13, 2012 12:53:14 PM

\*93030\*

ASAP

Page 1

Item ID: D4435-5

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Mount Bracket

Start Date: 11/13/2012 Start Qty: 9.00

\*9\*

Cust Item ID:

Required Date: 11/23/2012 Req'd Qty: 9.00

\*9\*

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 12-1-13

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4435

B

100

0.00

\*100\*

FLOW WATER-JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS  
15  
2-83

12 11 13

13

12-11-13

13

12-11-13

13

**Work Order ID 93030**

Tuesday, November 13, 2012 12:53:14 PM

**\*93030\***

Page 2

Item ID: D4435-5

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Mount Bracket

Stop **\*NS2\***

Start Date: 11/13/2012 Start Qty: 9.00

**\*9\***

Cust Item ID:

Required Date: 11/23/2012 Req'd Qty: 9.00

**\*9\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Bend as per dwg

0.00

**\*130\***

Brake NC

Memo

0.00

Brake NC

13

SP  
12/11/13

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control



12/11/14

13

160

Chemical Conversion Coat per QS1005 4.1

0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

13

26 12-11-14

**Work Order ID 93030**

Tuesday, November 13, 2012 12:53:14 PM

**\*93030\***

Page 3

Item ID: D4435-5

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Mount Bracket

Stop **\*NS2\***

Start Date: 11/13/2012 Start Qty: 9.00

**\*9\***

Cust Item ID:

Required Date: 11/23/2012 Req'd Qty: 9.00

**\*9\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

170

QC7-Inspect Chemical Conversion Coat

0.00

**\*170\***

QC

Memo

0.00

Quality Control

D4  
303  
88

12/11/14

190

Identify as per dwg & Stock Location: G-A

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

13  
FF

FF

12-11-14

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

12/11/15

12-11-15

# Picklist Print

Tuesday, November 13, 2012 12:53:14 PM

Page 1

Work Order ID: 93030  
 Parent Item: D4435-5  
 Parent Item Name: Mount Bracket

Start Date: 11/13/2012 Required Date: 11/23/2012  
 Start Qty: 9.00 Required Qty: 9.00

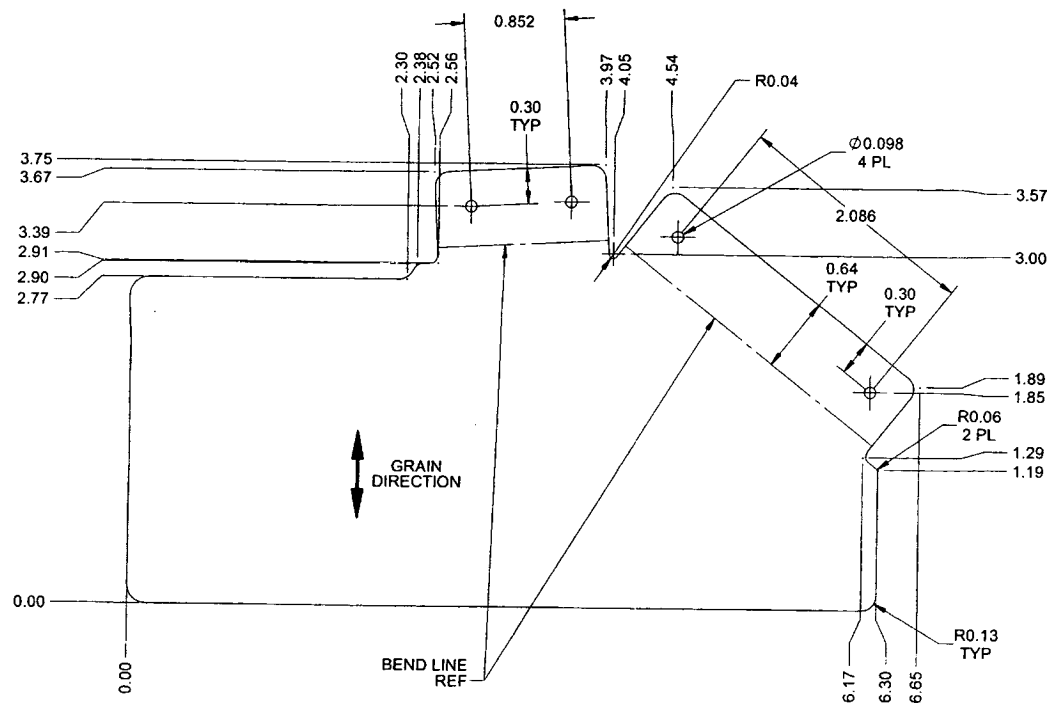
Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC IPP REV:B 12.03.06 AS PER  
 DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	159.6578	0.1732	1.6408421	2	12-11-13	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	159.6578	
121099	159.6578	

121659

(13)



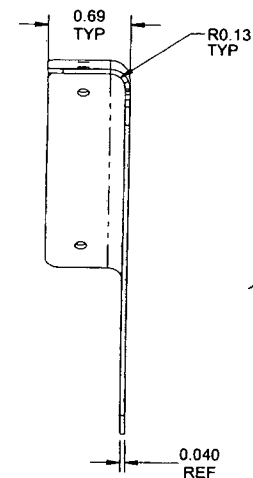
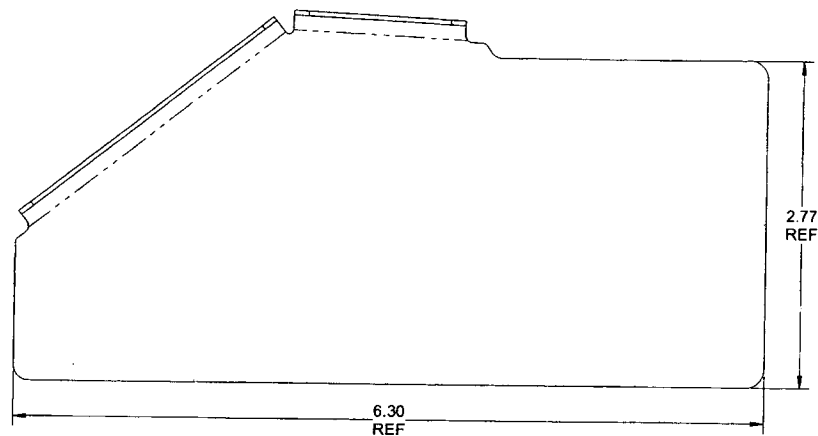
**D4435-5F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

RELEASED  
2012-03-02  
JMD

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO. <b>D4435</b>	REV. B
MFG. APPR.	140	SHEET 7 OF 11	
APPROVED	140	TITLE	SCALE
DE APPR.	140	<b>BRACKET</b>	NTS
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# 93030

# **D4435-5 MOUNT BRACKET**

RELEASED  
2012-03-02  
JN

## **NOTES:**

- 1) MATERIAL: MAKE FROM D4435-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	E	D4435	SHEET 6 OF 11
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